

Date: Friday, 23/01/2009 8:45:39 AM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : OUTSIDE WASHER
Job Number : 45170	
Estimate Number : 11153	
P.O. Number :	Part Number : D32333
This Issue : 23/01/2009 S.O. No. :	Drawing Number : D3233 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 42465	Material :
Written By :	Due Date : 05/02/2009 Qty: 20 Um: Each
Checked & Approved By : <u>JUD 09.01.23</u>	
Comment : Est. B 05.03.31 Added Powder Coat KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1020TR2000W500	1020-1025 round tubing 2.00 x .500w
Comment: Qty.: 0.0788 f(s)/Unit Total : 1.5750 f(s) 1020-1025.Round Tube Material: AISI 1020-1025 Seamless Tubing 2" x 0.500" wall (M1020TR2.000W.500) Identify for D3233-3 Batch: <u>M10201</u> <u>mk 09/01/27</u> (20)		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HARDINGE CNC LATHE SMALL Turn as per Folio FA518 and Dwg D3233 Deburr <u>mk 09/01/27</u> (20)		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>mk 09/01/27</u> (20)		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>SA 09/01/28</u> (20)		
5.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3  START TIME: <u>12:00</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>12:30</u> <u>BR 09-01-29</u> (20)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 23/01/2009 8:45:39 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTSIDE WASHER

Job Number: 45170

Part Number: D32333

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*MS*



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-29

*XED*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 483*

*SS 09/01/29 XED*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*09/02/02*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*END 09-01-29 (20)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

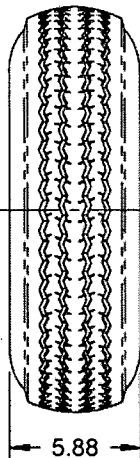
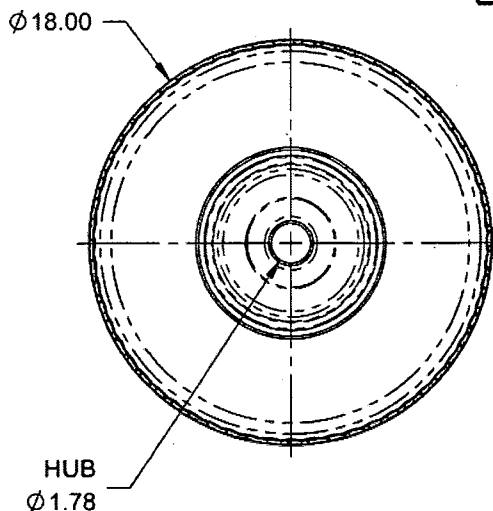
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



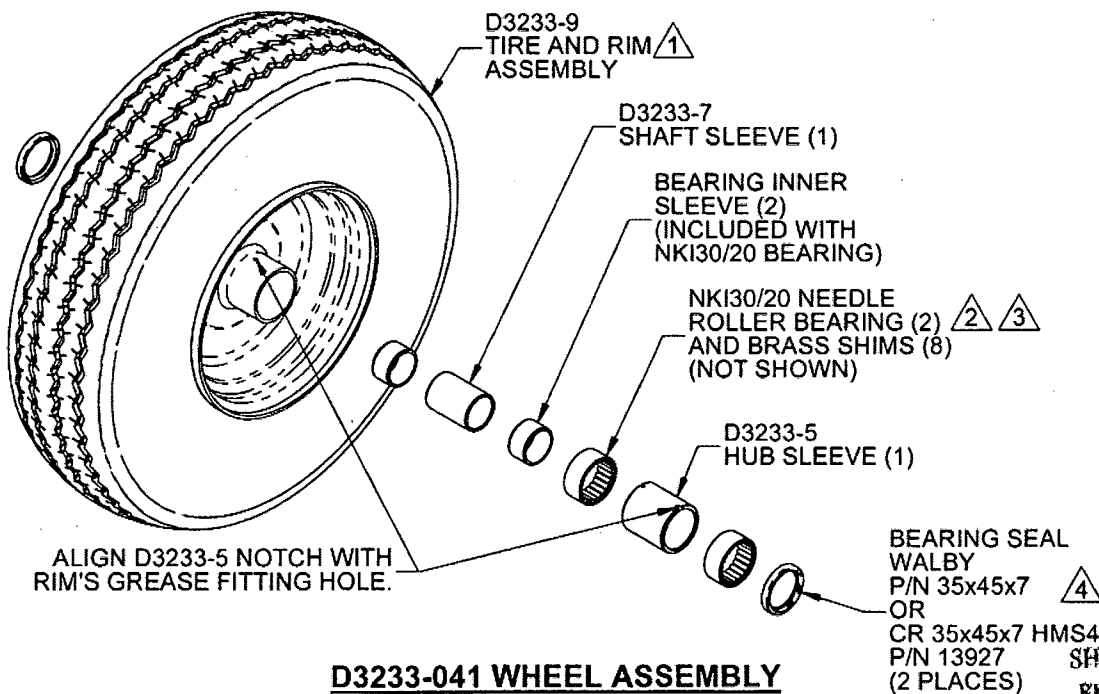
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3233</b>	REV. B SHEET 1 OF 3
DATE <b>05.03.08</b>		TITLE <b>WHEEL ASSEMBLY</b>	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	

**RELEASED**  
*[Signature]*  
05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

\* MANUFACTURER'S RECOMMENDATIONS  
ARE 75 PSI FOR HIGH SPEED USE.

**D3233-041 WHEEL ASSEMBLY****NOTES:**

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH  
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

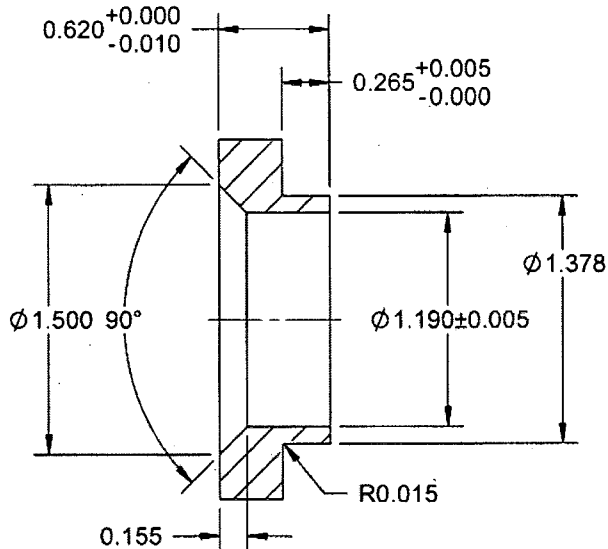
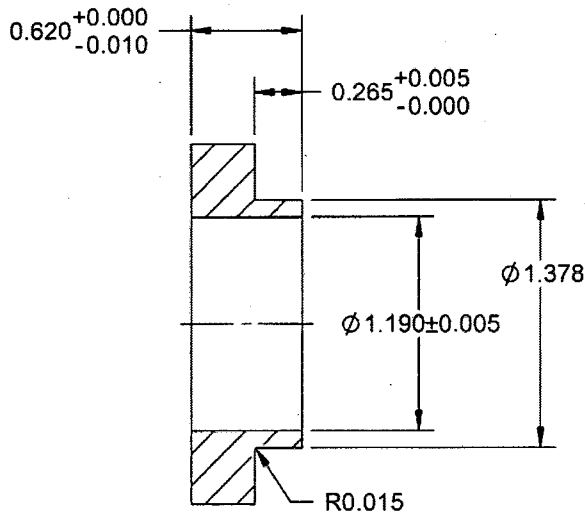
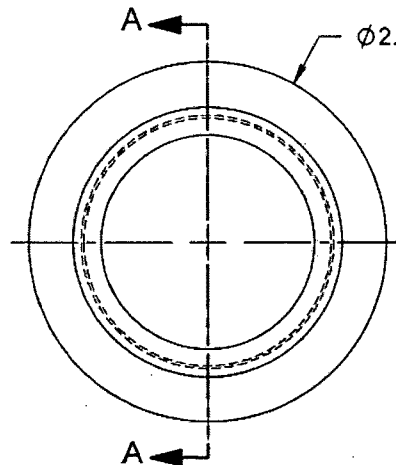
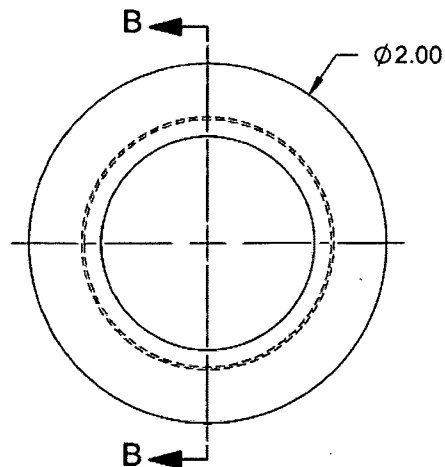
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3233</b>	REV. B SHEET 2 OF 3
DATE <b>05.03.08</b>		TITLE <b>WHEEL ASSEMBLY</b>	SCALE 1:1

**SECTION A-A****D3233-1 INSIDE WASHER****SECTION B-B****D3233-3 OUTSIDE WASHER****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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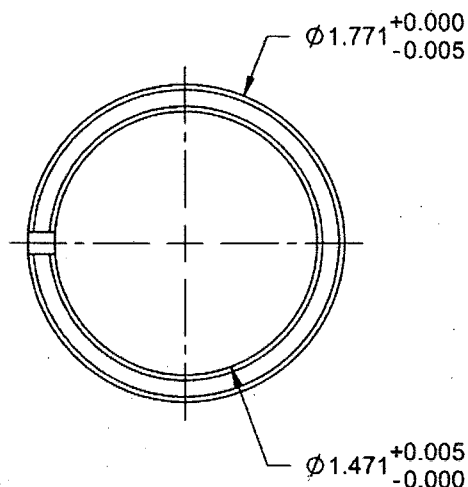
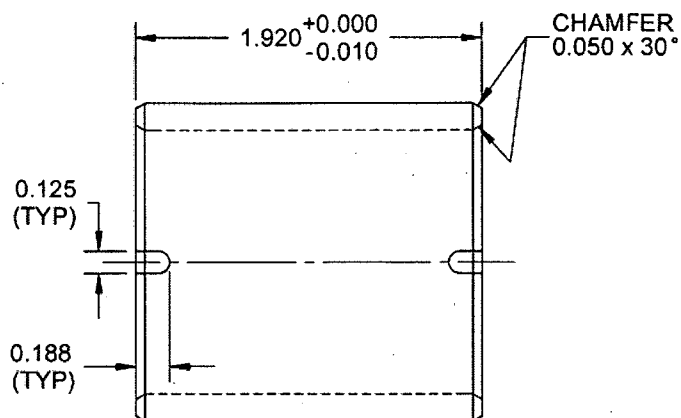
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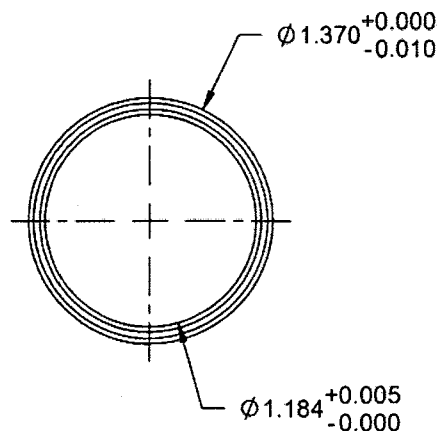
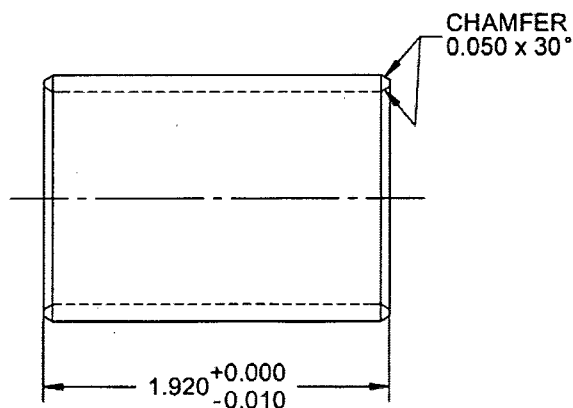


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

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*[Signature]*  
05/05/09



**D3233-5 HUB SLEEVE**



**D3233-7 SHAFT SLEEVE**

**NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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